

Work Order ID 146564

Thursday, May 19, 2016 2:54:06 PM

146564

Page 1

Item ID: D2530 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Handle Weldment
 Start Date: 6/13/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 6/22/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MCJ Date: MAY 24 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2530	Rev B								
100	Small Fab	0.00							
100									
Small Fab	Memo	0.84							
Small Fab	1-Cut to length as per Dwg D2536 2-Deburr								
110	QC6- Inspect dimensions to drawing	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Weld per dwg A/R S.S. rod Batch: <u>116577</u>	0.00							
120									
Large Fab	Memo	0.80							
Large Fab	1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301								

4 FF JUN 30 2016

(4) DAS
38
9-89
JUL 05 2016

4 2016/07/20
JM

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		☐ OTHER : _____							

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				4		AUG 12 2016	Cpl
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.08				(4)			DAS 38 389 AUG 12 2016
150 *150* Powdercoat Powder Coating	Black Sandtex(Ref: 4.3.5.7) per QSI005 4.3 n 129777 Memo START TIME: 10:40 OVEN TEMPERATURE: 320° FINISH TIME: 11:10.	0.00 0.08				4	0	16-08-17	389

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Date : _____		Step #: _____		QTY Effective : _____			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
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Picklist Print

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Page 1

Work Order ID: 146564

146564

Parent Item: D2530

D2530

Parent Item Name: Handle Weldment

Start Date: 6/13/2016

Required Date: 6/22/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:E Removed Purchasing 05-11-07 JLM IPP Rev:F
11.01.07 chg qc 5 to 6 DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2534 Manufactured No

120

Each

17.0000

2

8

D2534

Lock Plate

145921 x 8

16-08-11
JMS

Location

Loc Qty

Loc Code

WA004

17

139017

12

139602

5

M304TR0.750W.049

Purchased

No

100

f

202.1576

2.9145

12.27158

M304TR0 750W 049

304 RD Tube .750 x .049W

FF

JUN 30 2016

Location

Loc Qty

Loc Code

GA002

196.5848232

M132270

0.00001

M133131

0.0007242

M133509

14.210211

M133700

8.85327

M133914

5.98516

M134138

1.1364496

M134212

9.8302125

M134306

41.2895779

M134528

62.890263

M134604

52.388945

MAT

5.5727347

M133400

5.5727347

12.27158

DQA: _____ Date: _____



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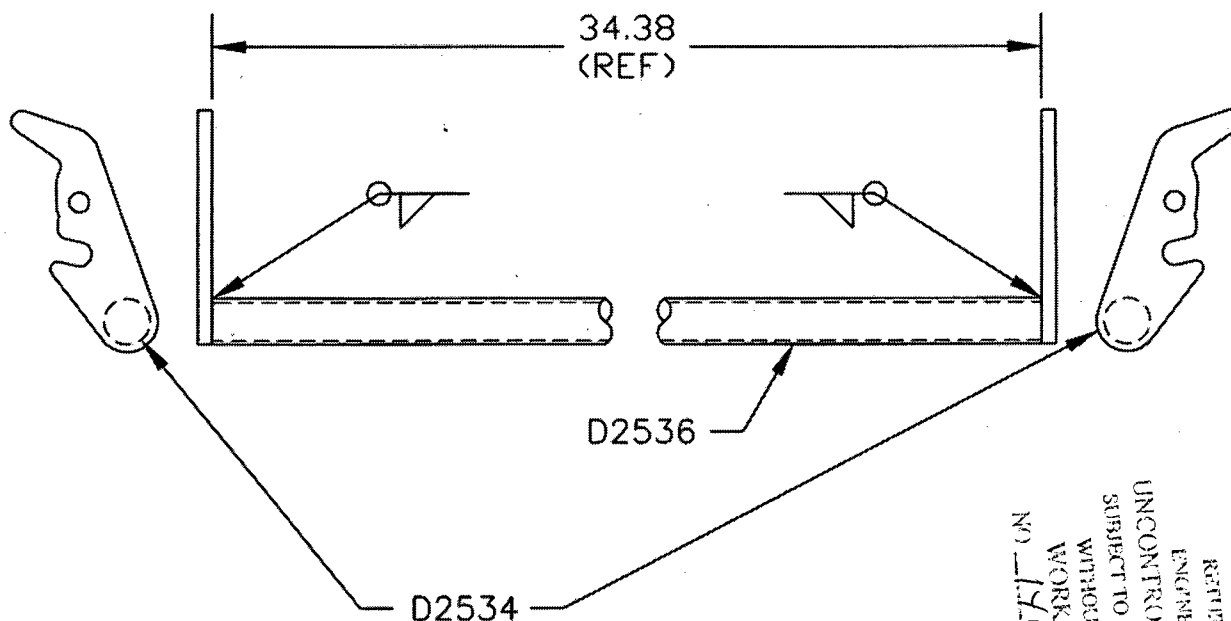
DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	PH	DRAWING NO.	REV. B
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	D2530	SHEET 1 OF 1
DATE	TITLE		SCALE
04.12.14	HANDLE WELDMENT		
A	96.06.18	NEW ISSUE	
B	04.12.14	UPDATE NOTES AND DIMENSIONS	

RELEASED

04.12.16 *[Signature]*

PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE



D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 176564-PL5
1605-24

